Date:

Wednesday, 09/07/2008 1:13:48 PM

lister:

Julie Lecocq

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

**Job Number** : 40396 : 10178

**Estimate Number** P.O. Number

This Issue

: 09/07/2008 : NC

Prsht Rev. First Issue : //

**Previous Run** 

: 40153

Written By

Checked & Approved By

Comment

: Est D 02.08.22 est E 06.12.11

Type

ecn 836

: MACHINED PARTS

EC

**Drawing Name** 

**Part Number** : D25941

**Drawing Number Project Number** 

: D2594 REV C : N/A : C

: PLUG

**Drawing Revision** 

Material

**Due Date** : 30/07/2008

Qtv:

200 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

1.0

M6061T6R0625

6061-T6 Round Bar .625"

**Description:** 



Comment: Qty.:

0.0547 f(s)/Unit Total: 10.9410 f(s)

Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)

1100-0 (QQ-A-225/1) Ø0.625" Rod

(M5052H32R0.625) or (M6061T6R0.625)

2.0

HARDINGE

HARDINGE CNC LATHE SMAL



Comment: HARDINGE CNC LATHE SMALL

1-Make as per Dwg D2594-1 and Folio FA262.

2-Break all sharp edges 0.010 max.

3.0

4.0

5.0

QC2

QC8



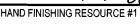
Comment: INSPECT PARTS AS THEY COME OFF MACHINE





Comment: SECOND CHECK

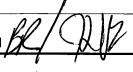
HAND FINISHING





Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1



SECOND CHECK



# **Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |  |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|--|--|
| DATE | STEP | PROCEDURE CHANGE   | Ву | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |  |
|      |      |                    |    |      |     |                                     |                          |  |  |  |
|      |      |                    |    |      | 1   |                                     |                          |  |  |  |
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|      |      |                    |    |      |     |                                     |                          |  |  |  |

| Part No: | PAR #: | Fault Category: | · | NCR: Yes No | DQA:   | Date: |
|----------|--------|-----------------|---|-------------|--------|-------|
|          |        |                 |   | QA: N/C     | losed: | Date: |

| NCR: |      | ,                 | WORK OR              | DER NON-CONFORMANO           | CE (NCR)       |              |                       |                          |  |  |  |
|------|------|-------------------|----------------------|------------------------------|----------------|--------------|-----------------------|--------------------------|--|--|--|
|      |      | Description of NC |                      | Corrective Action Section B  |                | Verification | A                     | Ammanal                  |  |  |  |
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Approval<br>Chief Eng | Approval<br>QC Inspector |  |  |  |
|      |      |                   | ·                    | ·                            |                |              |                       |                          |  |  |  |
|      |      |                   |                      |                              |                |              |                       |                          |  |  |  |
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|      |      |                   |                      |                              |                |              | ,                     |                          |  |  |  |

Date: Wednesday, 09/07/2008 1:13:49 PM User: Julie Lecocq **Process Sheet Drawing Name: PLUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 40396 Part Number: D25941 Job Number: Seq. #: Description: **Machine Or Operation:** POWDER COATING POWDER COATING 6.0 14107 025 Comment: POWDER COATING Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary) START TIME: 10:30pm OVEN TEMPERATURE: 320°F FINISH TIME: 11:00pm QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE # 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

| Dart Ae | rospace L | _td               |                      |                              |             |                    |                               |                          |
|---------|-----------|-------------------|----------------------|------------------------------|-------------|--------------------|-------------------------------|--------------------------|
| W/O:    |           |                   | WC                   | RK ORDER CHANGE              | S           |                    |                               |                          |
| DATE    | STEP      | PRO               | OCEDURE CHAI         | NGE                          | Ву          | Date Qty           | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |           |                   |                      |                              |             |                    |                               |                          |
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|         |           |                   |                      |                              |             |                    |                               |                          |
| Part No | :         | PAR #:            | Fault Categ          | jory:                        | NCR: Yes    | lo DQA:            | Date: _                       |                          |
|         |           |                   |                      |                              | QA: N/      | C Closed:          | Date: _                       | <u></u>                  |
| NCR:    |           |                   | WORK ORDE            | R NON-CONFORMAI              | NCE (NCR)   |                    |                               |                          |
|         |           | Description of NC |                      | Corrective Action Section    |             | Verification       | Approval                      | Approval                 |
| DATE    | STEP      | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign & Date | 1 & Section C Chie | Chief Eng                     | QC Inspector             |
|         |           |                   |                      |                              |             |                    |                               |                          |
|         |           |                   |                      |                              |             |                    |                               |                          |
|         |           |                   |                      |                              |             |                    |                               | l<br>i                   |

|      |      | Description of NC |                      | Corrective Action Section B  |                | Verification | erification Approval Section C Chief Eng | Annewal                  |  |
|------|------|-------------------|----------------------|------------------------------|----------------|--------------|--|--------------------------|--|
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    |  | Approval<br>QC Inspector |  |
|      |      |                   |                      |                              |                |              |  |                          |  |
|      |      |                   |                      |                              |                |              |  |                          |  |
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| }    |      |                   |                      | ·                            |                |              |  |                          |  |
|      |      |                   |                      |                              |                |              |  |                          |  |

| DART AEROSPACE LTD           | Work Order:  | 103910      |
|------------------------------|--------------|-------------|
| Description: Plug            | Part Number: | D2594-1     |
| Inspection Dwg: D2594 Rev: C |              | Page 1 of 1 |

### FIRST ARTICLE INSPECTION CHECKLIST

| X F | irst Article | F | Prototype |
|-----|--------------|---|-----------|
|-----|--------------|---|-----------|

| Drawir<br>Dimens |   | Tolerance     | Actual Dimension | Accept     | Reject | Method of<br>Inspection | Comments |
|------------------|---|---------------|------------------|------------|--------|-------------------------|----------|
| 0.060            | ) | +/-0.005      | 3060             | 7          |        |                         |          |
| 0.500            | ) | +/-0.010      | .499             | <b>✓</b>   |        |                         |          |
| Ø 0.625          | 5 | +/-0.010      | x (1)7           | <b>S</b>   |        |                         |          |
| <b>g</b> 0.430   | ) | +0.000/-0.002 | 5.U30            | <b>- /</b> |        |                         |          |
| 0.090            | ) | +0.000/-0.002 | .090             | J          |        |                         |          |
| 0.045            | 5 | +0.000/-0.002 | .044             |            |        |                         |          |
|                  |   |               |                  |            |        |                         |          |
|                  |   |               |                  |            |        |                         |          |
|                  |   |               |                  |            |        |                         | ,        |
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|                  |   |               |                  |            |        |                         |          |
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|                  |   |               |                  |            |        |                         |          |
|                  |   |               |                  |            |        |                         |          |
|                  |   |               |                  |            |        |                         |          |
|                  |   |               |                  |            |        |                         |          |
|                  |   |               |                  |            |        |                         |          |

| Measured by: mm= | Audited by:    | Prototype Approval: | N/A |
|------------------|----------------|---------------------|-----|
| Date: 08/07/16   | Date: 08/07//6 | Date:               |     |

| Rev | Date     | Change           | Revised by | Approved |
|-----|----------|------------------|------------|----------|
| A   | 04.01.21 | New Issue        | KJ/RF      | 1        |
| В   | 06.12.20 | Dwg Rev. updated | KJ/JLM     |          |
|     |          |                  | 777        | /~/      |

## **Dart Aerospace Ltd**

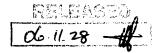
|  | WORK ORDER CHANGES |  |      |     |                                     |                          |  |  |
|--|--------------------|--|------|-----|-------------------------------------|--------------------------|--|--|
|  |                    |  | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |
|  |                    |  |      |     |                                     |                          |  |  |
|  |                    |  |      |     |                                     |                          |  |  |
|  |                    |  | :    |     |                                     |                          |  |  |
|  |                    |  |      |     |                                     |                          |  |  |
|  | STEP               |  |      |     |                                     | Approval                 |  |  |

| art No: | PAR #: | Fault Category: | NCR: Yes No | DQA:    | Date: |
|---------|--------|-----------------|-------------|---------|-------|
|         |        |                 | QA: N/C     | Closed: | Date: |

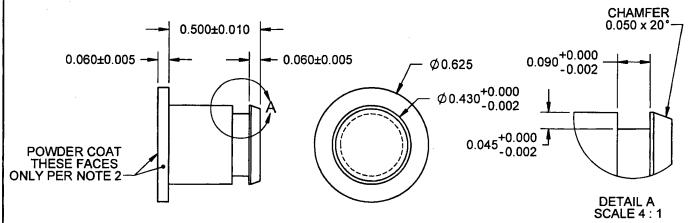
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR)  |                              |                |           |              |              |          |  |
|------|------|-----------------------------------|------------------------------|----------------|-----------|--------------|--------------|----------|--|
|      |      | STEP Section A Initial Action Des | Corrective Action Section B  |                |           | Verification | Approval     | Approval |  |
| DATE | STEP |                                   | Action Description Chief Eng | Sign &<br>Date | Section C | Chief Eng    | QC Inspector |          |  |
|      |      |                                   |                              |                | -         |              | ·            |          |  |
|      |      |                                   |                              |                |           |              |              |          |  |
|      |      |                                   |                              | 4              |           |              |              |          |  |
|      |      |                                   |                              |                |           |              |              |          |  |
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| `    |      |                                   |                              |                |           |              |              |          |  |
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|      |      |                                   |                              |                |           |              |              | •        |  |



| DESIG | N #  | DRAWN BY | DART AERC<br>HAWKESBURY, C | OSPACE LTD<br>Intario, canada |
|-------|------|----------|----------------------------|-------------------------------|
| CHEC  | KED  | APPROVED | DRAWING NO.                | REV. C                        |
|       | E    | - DU     | D2594                      | SHEET 1 OF 1                  |
| DATE  |      |          | TITLE                      | SCALE                         |
|       | 06.1 | 1.20     | PLUG                       | 2:1                           |
| REV   |      | DATE     | DESCR                      | RIPTION                       |
|       |      |          | 415:41:44:15               |                               |



|     |          | <del></del> -  |
|-----|----------|--|
| REV | DATE     | DESCRIPTION  |
| Α   | 96.09.16 | NEW ISSUE  |
| В   | 97.03.15 | ADD GROOVE AND O-RING  |
| С   | 06.11.20 | ADD PWDR COAT; ADD MS P/N TO D2594-3;<br>ADD AMS SPECS; ADD TOLERANCE NOTE |



### **D2594-1 PLUG**

- D2594-1 PLUG NOTES:

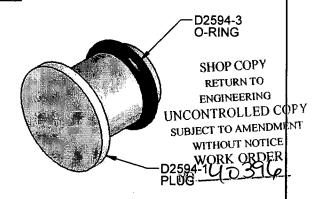
  1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
  2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 AS TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:** 1) 5/16 ID, 7/16 OD, 1/16 WIDTH

2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 /C\

**PARTS LIST:** 

| QTY | P/N     | DESCRIPTION   |
|-----|---------|---------------|
| Х   | D2594   | PLUG ASSEMBLY |
| 1   | D2594-1 | PLUG          |
| 1   | D2594-3 | O-RING        |



### **D2594 PLUG ASSEMBLY**

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## Dart Aerospace Ltd

| W/O:                     |                       | WORK ORDER C |    |      |     |                                     |                          |
|--------------------------|-----------------------|--------------|----|------|-----|-------------------------------------|--------------------------|
| DATE                     | STEP PROCEDURE CHANGE |              | Ву | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|                          |                       |              |    |      |     |                                     |                          |
| orker, all Primer livery |                       | -            |    |      |     |                                     |                          |
|                          |                       |              |    |      |     |                                     |                          |

| Part No: | PAR #: | Fault Category: | NCR: Yes | No <b>DQA:</b> | Date: |  |
|----------|--------|-----------------|----------|----------------|-------|--|
|          |        |                 | QA: N    | /C Closed:     | Date: |  |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |   |             |                           |                       |                          |  |
|------|------|----------------------------------|----------------------|---|-------------|---------------------------|-----------------------|--------------------------|--|
| DATE |      | Description of NC                |                      | Corrective Action Section B   |             |                           | Ammanual              | Ammound                  |  |
|      | STEP | Section A                        | Initial<br>Chief Eng | Action Description Chief Eng  | Sign & Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |
|      |      |                                  |                      | •   |             |                           |                       |                          |  |
|      |      |                                  |                      |   |             |                           |                       | į                        |  |
|      |      |                                  |                      |   |             |                           |                       |                          |  |
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